

ASAP

Dart Aerospace Ltd.

Date: Wednesday, 3/7/2007 4:11:21 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HOOK		
Job Number	: 31095		Part Number	: D30465		
Estimate Number	: 12597		Drawing Number	: D3046 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 3/7/2007	S.O. No. : N/A	Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 3/12/2007		
Previous Run	: 29793		Qty:	50	Um:	Each
Written By						
Checked & Approved By						
Comment	: Est A 06.12.01		New Issue EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M174B0375X1000	17-4 SS Bar 3/8 x 1"
Comment: Qty.: 0.1397 f(s)/Unit Total : 6.9825 f(s) 17-4PH Stainless Steel Bar 3/8" x1.00" Batch: M102942 mk 07/03/08 51		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blank 1.600" long mk 07/03/08 51		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1		
1- Mill as per Folio FA659 Rev: A & Dwg D3046 Rev: B mk 07/03/08 51		
2-Deburr per dwg D3046 mk 07/03/08 51		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE mk 07/03/08 51		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK SD 07.03.12 51		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/13
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:11:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOOK

Job Number: 31095

Part Number: D30465

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

FC 07/02/12 (51)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



(51)

Comment: FINAL INSPECTION/W/O RELEASE

170703/13

Job Completion



U 07-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

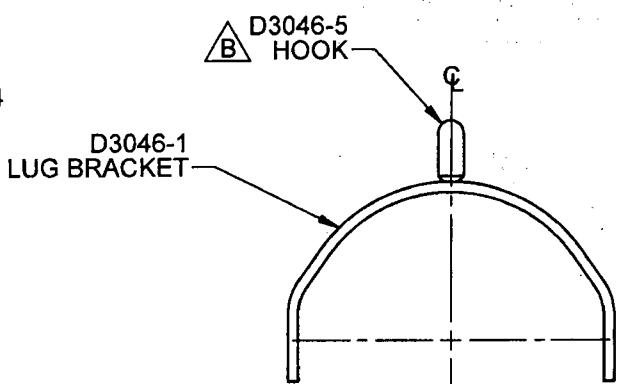
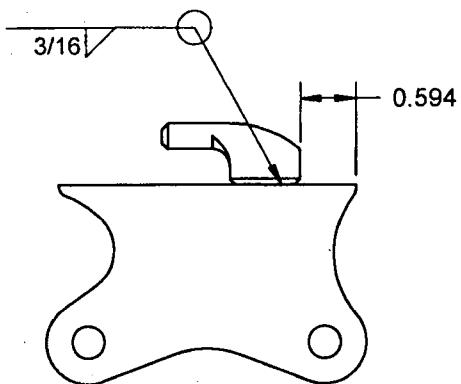
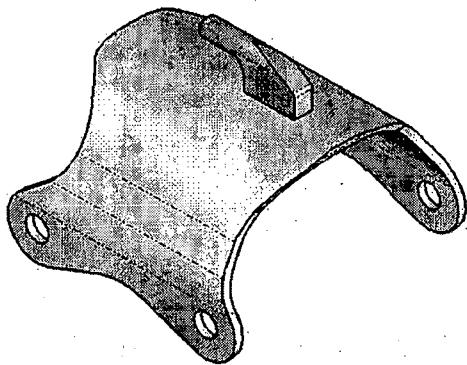
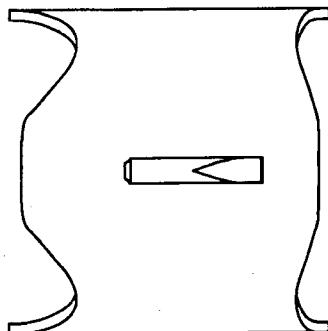
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	D3046	REV. B SHEET 1 OF 3
DATE	06.10.26	TITLE	LUG BRACKET ASSEMBLY	SCALE 1:2

REV	DATE	DESCRIPTION
A	01.08.23	NEW ISSUE
B	06.10.26	ADD D3046-5 REMOVE D3046-3; INCREASE HOLE DIAMETER OF D3046-1; CHANGE MATERIAL TO 17-4PH FROM 1010 STEEL

RELEASED

06.11.13



D3046-041 LUG BRACKET ASSEMBLY

QTY	P/N	DESCRIPTION
X	D3046-041	GROUND HANDLING LUG ASSEMBLY
1	D3046-1	LUG BRACKET
1	D3046-5	HOOK

B

NOTES:

- 1) FINISH: HEAT TREAT ASSEMBLY TO H900 HARDENED CONDITION (MIN 190 KSI)
POWDER COAT ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005.4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) WELD PER DART QSI 004
- 5) PART IS SYMMETRICAL ABOUT C
- 6) IDENTIFY WITH P/N D3046-041 USING FINE POINT PERMANENT INK MARKER

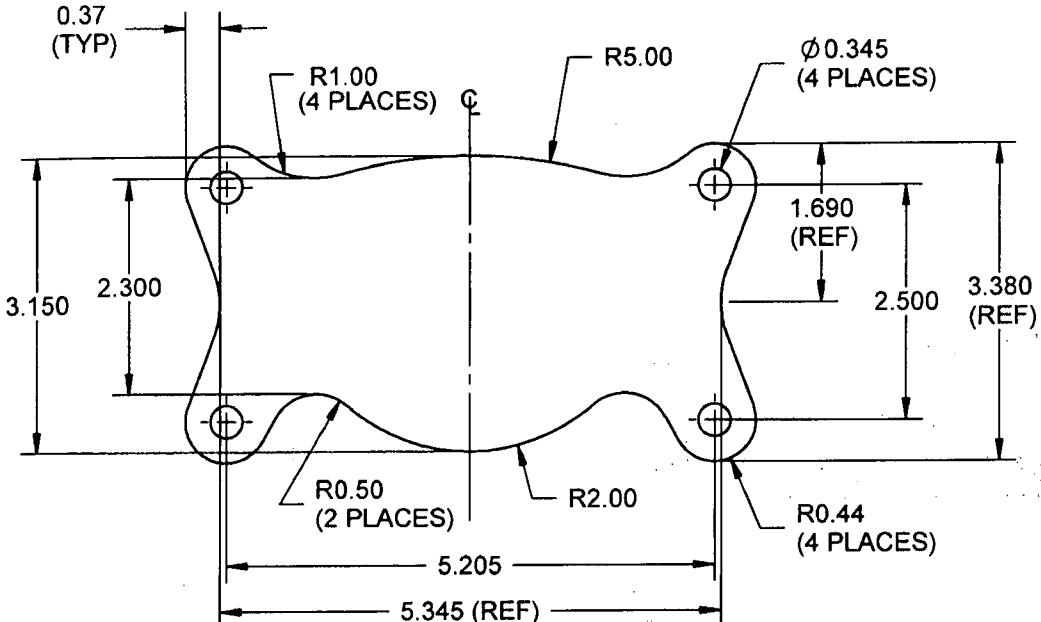
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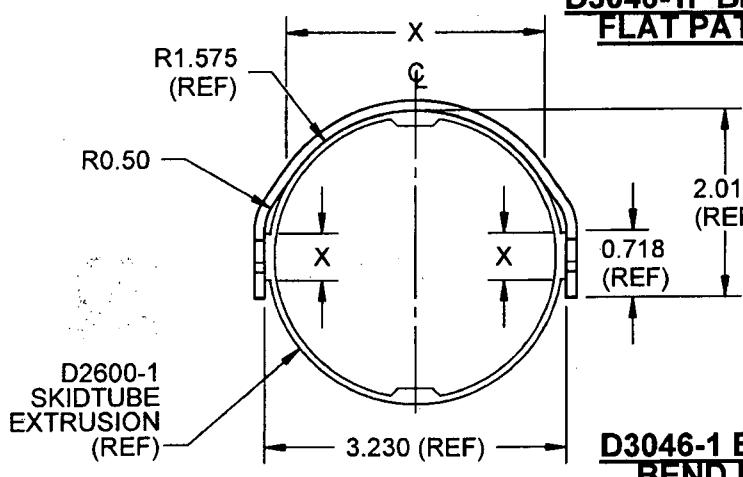
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DART

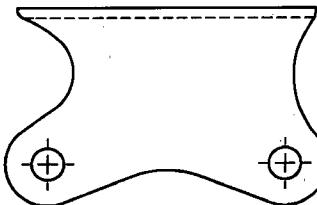
DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		D3046	SHEET 2 OF 3
	06.10.26	TITLE	SCALE
		LUG BRACKET ASSEMBLY	1:2



**D3046-1F BRACKET
FLAT PATTERN**



**D3046-1 BRACKET
BEND DETAIL**



RELEASED

06/11/13

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 0.109" THICK (12 GAUGE) PER AMS 5604 (REF DART SPEC M17-4-S12GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) D3046-1 SHOULD BE BENT USING DT8351 TOOL SO THAT IT IS WITHIN 0.010" OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X'.

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3046
DATE	06.10.26	TITLE LUG BRACKET ASSEMBLY

REV. B

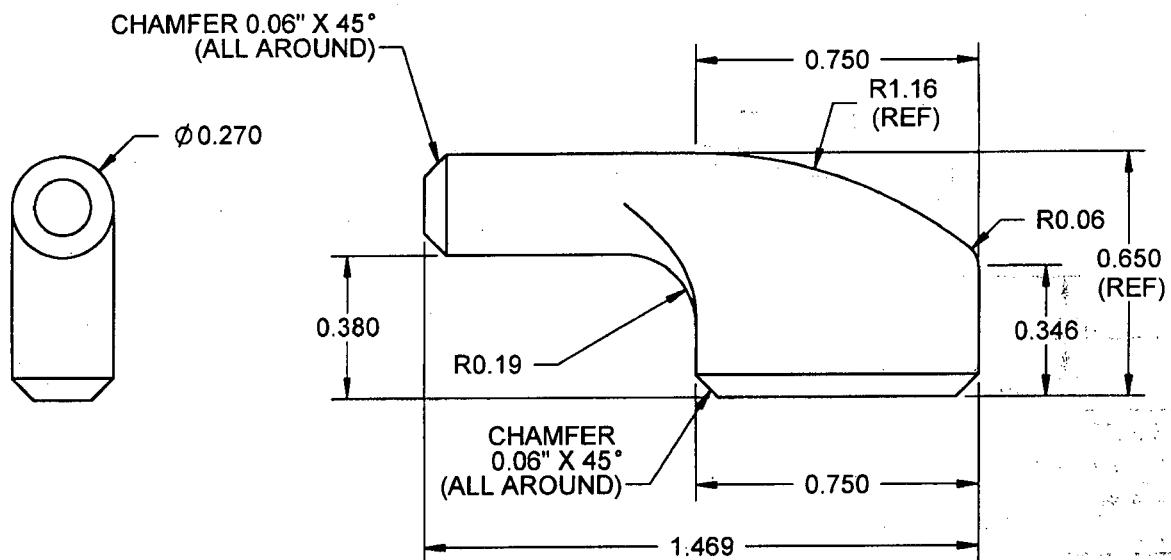
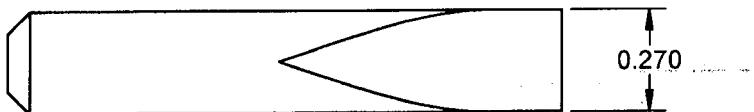
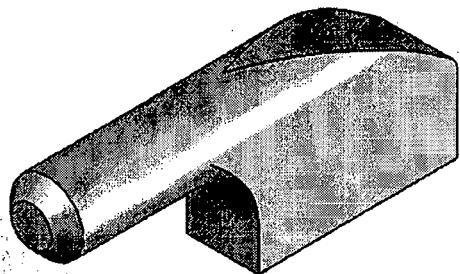
SHEET 3 OF 3

SCALE

2:1

RELEASED

06.11.13

D3046-5 HOOK **NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL BAR PER AMS 5604 OR AMS 5643 ENGINEERING (REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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WORK ORDER

NO. 31095

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DART AEROSPACE LTD	Work Order:	31095
Description: HOOK	Part Number:	D3046-5
Inspection Dwg: D3046, Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Measured by:	<i>Jnk</i>
Date:	02/10/08

Audited by:	J.L.
Date:	07/03/08

Prototype Approval: NA
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	